

Date: Thursday, 11/29/2007 11:06:55 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD *spl + 08/01/02*
 Job Number : 36040 -1
 Estimate Number : 12712
 P.O. Number : *N/A*
 This Issue : 11/29/2007 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : *N/A* Type : SMALL /MED FAB
 Previous Run : 35696
 Part Number : D35371
 Drawing Number : D3537 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : *N/A*
 Due Date : 12/10/2007 Qty: *70* Um: 100 Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev: A New Issue 07-02-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 .063 Sheet



Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: *105997* *IB 07-12-6*

8.5104

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: *C*

Prog Rev: *C*

IB 07-12-6

108

2-Deburr if necessary

IB 07-12-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 07-12-6

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

7/12/06 *(108)*

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE



1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

SB 07/12/11 *(108)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 08/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/12/06	# 2.0	6 parts have a dim. of 3.600 instead of 3.625 f.c. water get cut too small.	<u>PH</u> 07.12.06 por 0252042	Parts are acceptable this on time only. Acceptable edge distance remains based on E/D=1.5	<u>IB</u> 07.12.06	 7/12/06	<u>PH</u> 07.12.06 por 0252042	 7/12/06

NOTE: Date & initial all entries

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Drawing Name: WEARPAD

Job Number: 36040

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M106390/M105959

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

8/01/10 (50x)

8/01/02 (38x)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-10

38

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-01-10 (50)

38

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M106442

08/01/10

(50x)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-10

(50)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

8/01/10

08-01-10

(50)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

(50)

Job Completion



08-01-11

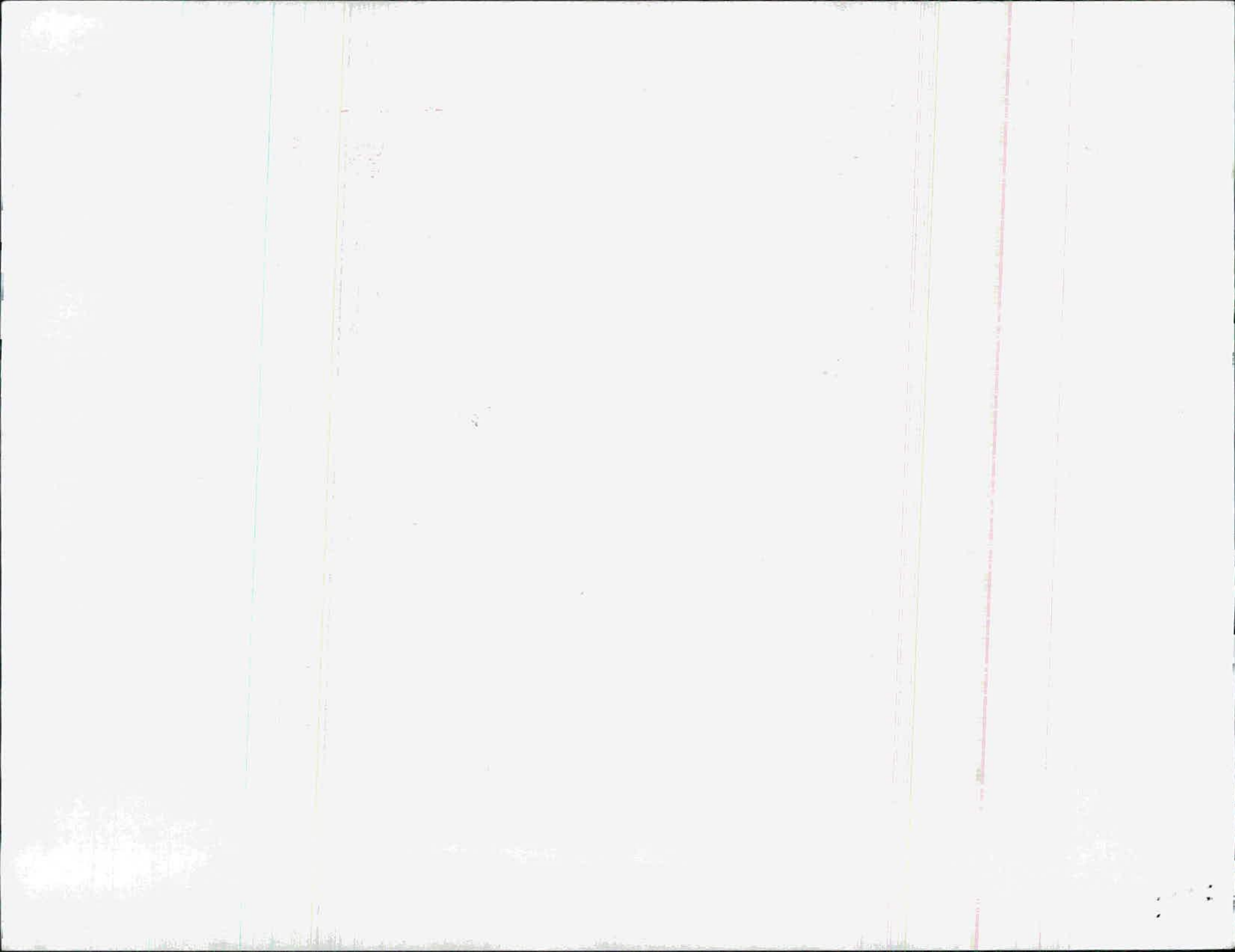
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

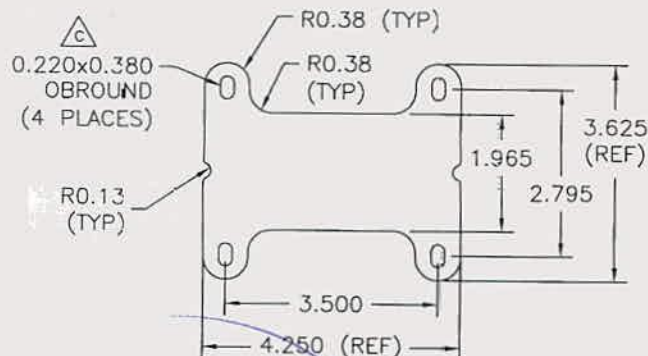
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

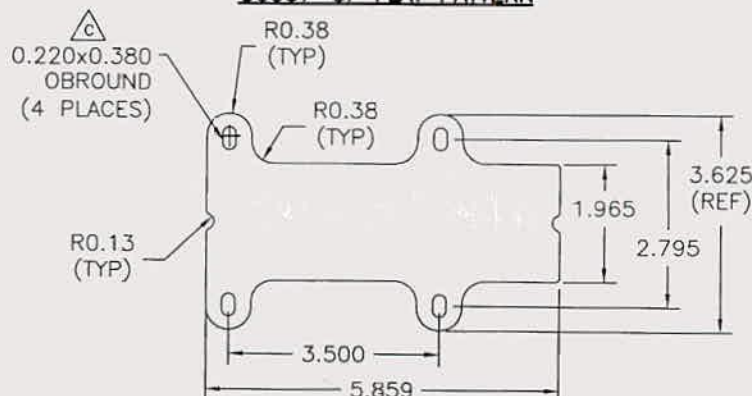
NOTE: Date & initial all entries



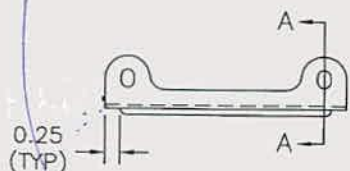
D3537-1F FLAT PATTERN



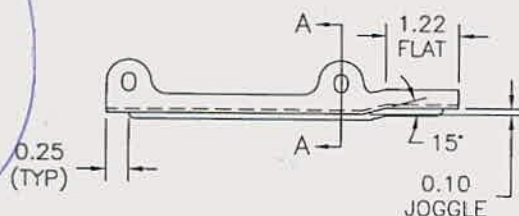
D3537-3F FLAT PATTERN



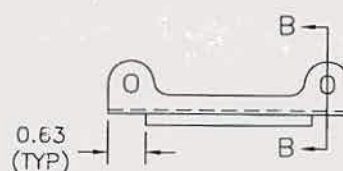
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

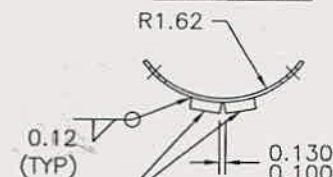


SECTION A-A



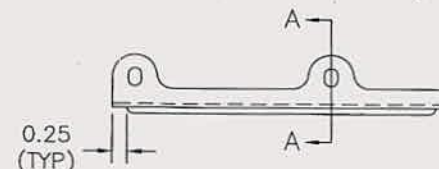
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE
		1:2

RELEASED
07-05-08 PM
REF ECAJ
962

NO. 36040
WORK ORDER
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